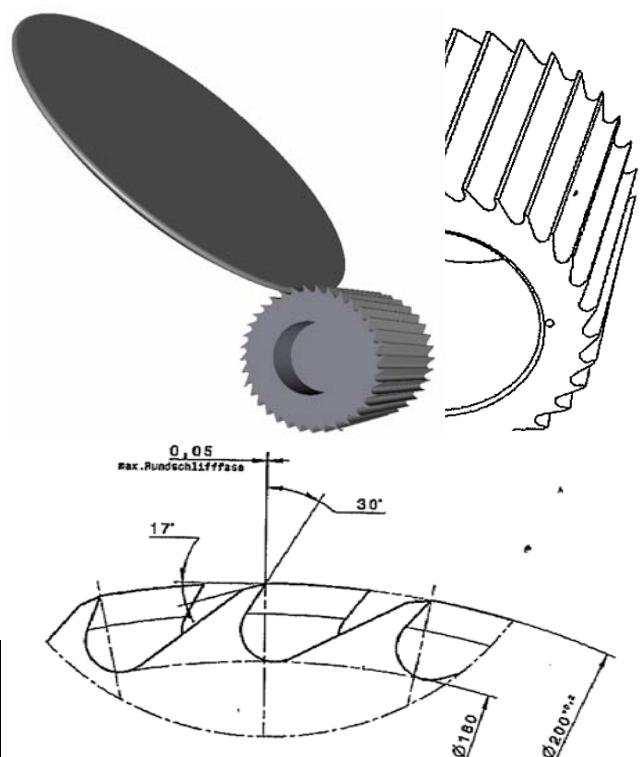


Rotor Cutter Ø200 Z36

A03-101

Flute grinding of the rotor cutter for plastics is done in two operations. 2 passes for roughing using the roughing wheel. The second wheel is only used for finishing and can therefore be maintained over long production lots. High pump capacities of 16 to 20 bar are needed for the coolant unit.



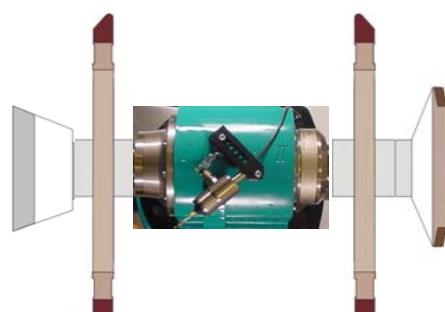
1. Cycletime for Production

Workpiece:	Ø 200 mm, Z 36, L 200 mm, Helix 3° Material HSS/PM390			
Operations	Flute rough	Flute fin	O.D.2	Cyl. Land
Feed [mm/Min]	60	120	300	10
Power [kW]	12	5	1	2
Cutting feed [m/s]	45	45	32	32
Used wheels	1	2	3	4
Grinding time [s]	17064	8083	1626	1209
Total cycle time	466 Min 21			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1V1 Ø200 B126 R3.5
2	1V1 Ø200 B126 R3.5
3	11V9 Ø100 B126
4	12V2 Ø125-150 B126



3 2

1 4

3. Machine and Software Requirements

Machines: 5 axes CNC grinder: GEMINI DMR 26 kWh
 Control: Fanuc 310i
 Accessories:
 Responsable engineer: OP. 12.11.10

Coolant: Synthetic Oil, pressure 16-20 bar
 Software: Quinto 5

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